



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6405G02131-3G-1
Job Sheet 171013



Part No: RBW6405G02131-3G-1

Job Qty: 2 ea

Part Name: Bolt



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/25/18

Job Tracking No:

Due Date: 1/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW6405G02131-3G REV D SHEET 2 IPP Rev.A 17.08.29 New issue DP Verify DD IPP Rev B 17.11.14 Rev B DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		1/16/18	0.00	0.00	Start Up Machining-3		✓ 18-1-29
110	CNC Lathe	2 pcs		1/17/18	0.00	1.00	MORI SL-154		✓
120	QC	2 pcs		1/17/18	0.00	0.00	QC2 Machining-4		✓
130	QC	2 pcs		1/17/18	0.00	0.00	QC8 Machining-4		✓ 8/01/20
140	QC	2 pcs		1/17/18	0.00	0.00	QC5		✓
180	Outsource	2 pcs		1/31/18			GRO002-VC Outsource 1013		AT 18/02/14
190	Packaging	2 pcs		1/31/18	0.00	0.00	Packaging2		AT 08/02/14
200	QC	2 pcs		1/31/18	0.00	0.00	QC6		✓
210	Packaging	2 pcs		1/31/18	0.00	0.00	Packaging3-1		✓ FEB 16 2018
220	QC21-SA	2 Ea		1/31/18	0.00	0.00	QC21		✓ FEB 16 2018

Part Op 110 - 1-Machine as per DWG. FB623 FOLIO REV: _____ DWG REV: _____ 2-Debur 9-80

Descriptions: 180 - -Issue P/O to Groupe Altech: P/O 03898 -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required

JAN 31 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R0.750	AISI 4140 Quenched & Tempered Steel Round Bar 0.750" Dia.	1.2000 ft (.6 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R0.750	1	18	0
	5033398	1.08		

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



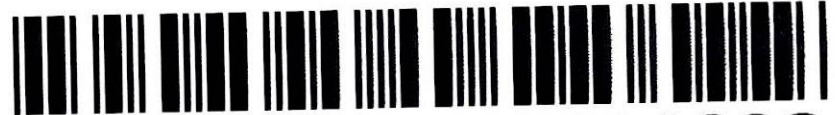
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		☐
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval					
Description Work Order Deviation			Disposition			Completed By				
						Lead hand / Supervisor Approval Verification				

Root Cause		
Environment	☐	No Re-verification
Design	☐	Operator
Doc/Data	☐	Offset/Setup
Equip/Tooling	☐	Supplier
Handling/Pre	☐	Training
Material	☐	Use for Testing
Internal Transport	☐	Poor Information
Tribal Knowledge	☐	Rushing
LOA	☐	Product Improvement
Substation	☐	Process Improvement
Past Expiry Date	☐	Manufacturing Process
Misidentified	☐	Past Due
		OTHER :

Change No: _____
Operation: _____
Revision: _____
Original Serial #: S036402
PART NO: RBW6405G02131-3G-1



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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com



DQA: _____ Date: _____

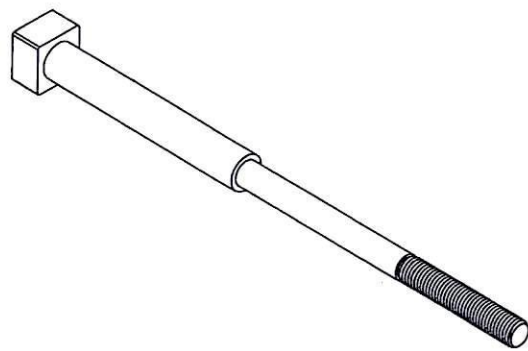
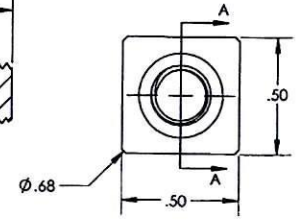
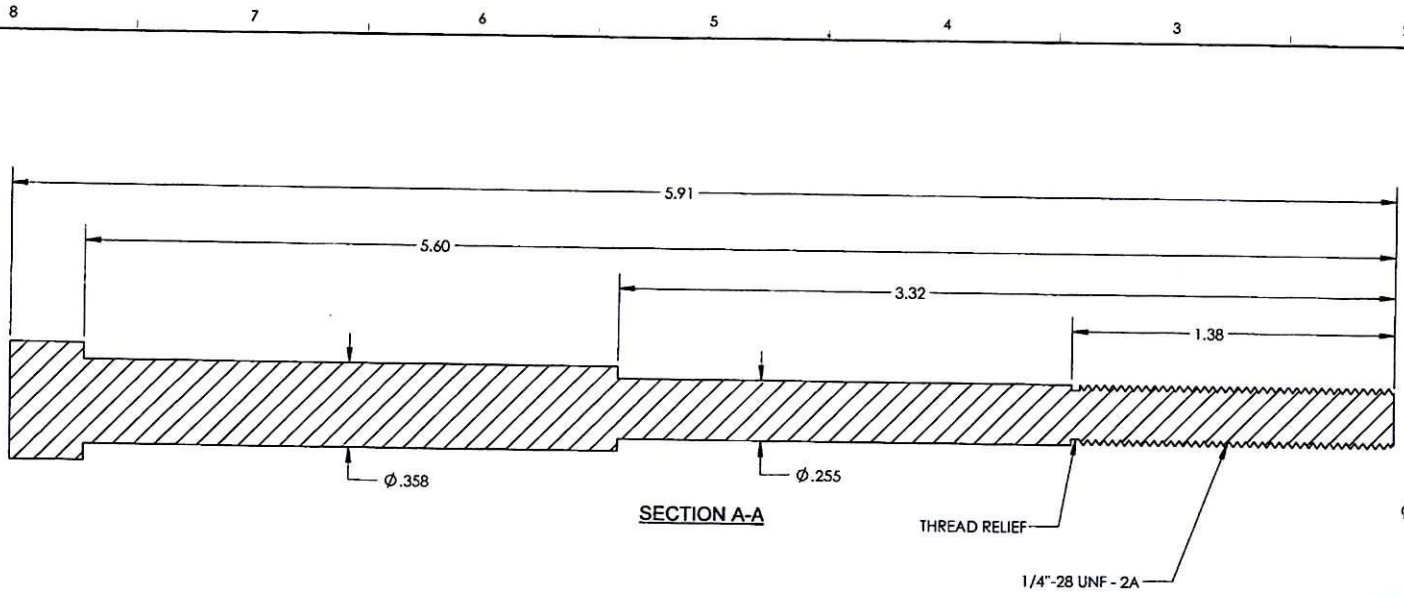
WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			



RBW6405G02131-3G-1 BOLT

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 171013 ncs
 18-01-25

- NOTES:
 1) MATERIAL: AISI 4140/4142 Q & T
 2) HEAT TREAT: 28-34 Rc
 3) FINISH: ZINC PLATE
 4) SPEC: ASTM B633 TYPE I, SC 2
 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
 6) IDENTIFICATION: N/A

		Hawthornby, Ontario, Canada	
		BOLT	
DWG NO. RBW6405G02131-3G-1		REV D	
DESIGN BY: VM 10/19/2017	CHECKED: VM 10/30/2017	1. DIMENSIONS ARE IN INCHES 2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: VM 10/30/2017	CHECKED: VM 10/30/2017		
MFG. APPR: VM 10/31/2017	CHECKED: VM 11/02/2017		
DATE: 10/30/2017			
SCALE: NTS	WEIGHT: 0.132 LBS	SHEET 2 OF 4	
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Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038918

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			P/O : _____ Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread							
7	170543	RBW109-3101-58-1-3	Hammer Head -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	2/8/18	6 pcs / 6x	0 pcs	6 pcs	\$2.39/pcs	\$14.34
8	171013	RBW6405G02131-3G-1	Bolt -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required	Firmed	2/8/18	2 pcs / 2x	0 pcs	2 pcs	\$3.00/pcs	\$6.00
Grand Total:										\$1,363.13

DAS
38
9-89

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CL
B

Plex 2/5/18 9:09 AM dart.baker.diane



Certificat de Conformité / Certificate of Compliance

(006394-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

006394 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
14-Feb-2018		Curtis Anderson		038918				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6405G02131-3G-1 Rev.	BOLT 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] SPÉC: ASTM B633 TYPE 1 SC2 ***	ZINC CH	2	2	0	0	0
2	RB6796941-14 Rev.	PLUG BLACK OXIDE MIL-C-13924C CLASS 1	BLACK-OXIDE CH	5	5	0	0	0
3	647.7701 Rev.	647.7701 CAD PLATE IAW QQ-P-416F CLASS 1 TYPE 2 CAD PLATE SHOULD NOT BE TO THICK AROUND TREAD	CADMIUM CH	10	10	0	0	0
4	RBT18560-11 Rev.	RBT18560-11 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	OXIDE-BLACK CH	12	12	0	0	0
5	RBW109-3101-58-1-3 Rev.	RBW109-3101-58-1-3 01 -ZINC [ZINC] SPÉC: ASTM B633 TYPE 1, SC2 *** SPÉC: CONFORMITY IS REQ. ***	ZINC CH	6	6	0	0	0
6	647-7703 Rev.	647-7703 CAD PLATE IAW QQ-P-416F CLASS 1 TYPE II	CADMIUM CH	16	16	0	0	0
7	RBW109-3101-58-1-3 Rev.	RBW109-3101-58-1-3 01 -ZINC [ZINC] SPÉC: ASTM B633 TYPE 1, SC2 *** SPÉC: CONFORMITY IS REQ. ***	ZINC CH	6	6	0	0	0
8	RBW6405G02131-3G-1 Rev.	BOLT 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] SPÉC: ASTM B633 TYPE 1 SC2 ***	ZINC CH	2	2	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.